

Work Order ID 61167

August 10, 2010 12:43:41 PM



Page 1

Item ID: D3935-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Pylon Wall Protector, LH

Start Date: 8/10/10 Start Qty: 1.00

Cust Item ID:

Required Date: 8/13/10 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3935

B

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg D3935

Dwg Rev: B

Prog Rev: B

2- Deburr if necessary

HB 10-8-10

(A)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

HB 10-8-10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61167

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Item ID: D3935-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Pylon Wall Protector, LH

Start Date: 8/10/10 Start Qty: 1.00

Cust Item ID:

Required Date: 8/13/10 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: _____

0.00

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

(x4)

10/8/10

SP (40)

10/08/11

MF

10-8-11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 61167

Parent Item: D3935-1

Parent Item Name: Pylon Wall Protector, LH



Start Date: 8/10/10

Required Date: 8/13/10

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04 GE PLASTICS LEXAN SHEET		Purchased	No			100	sf	2,917.906	8.69	9.147368			



8-10-8-10

Location

Loc Qty

Loc Code

MAT	2917.9068
112585	31.983
114032	467.9238
115261	2418

112585

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 61167	
Description: Pylon Wall Protector, LH		Part Number: D3935-1	
Inspection Dwg: D3935 <i>Rev: A Rev B</i>		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

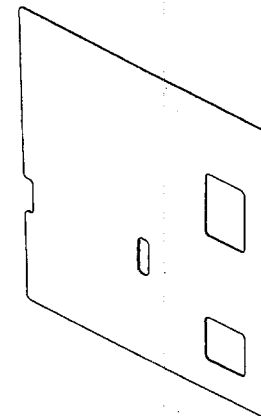
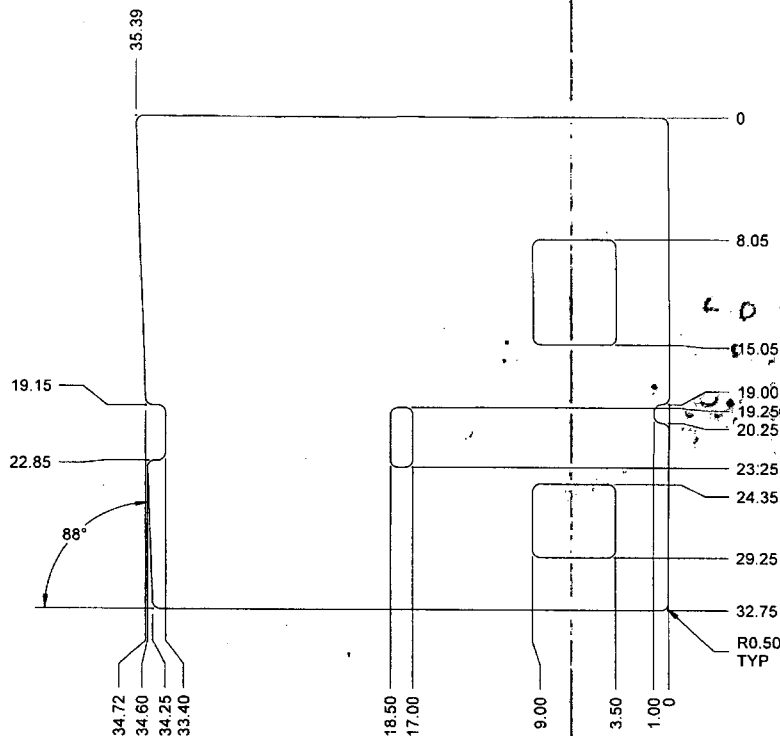
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
8.05	+/-0.030	8.05	X		T BGI	
15.05	+/-0.030	15.05	X		T	
19.00	+/-0.030	19.00	X		T	
19.25	+/-0.030	19.25	X		T	
20.25	+/-0.030	20.25	X		T	
23.25	+/-0.030	23.25	X		T	
24.35	+/-0.030	24.35	X		T	
29.25	+/-0.030	29.25	X		T	
32.75	+/-0.030	32.75	X		T	
1.00	+/-0.030	1.00	X		V BGI	
3.50	+/-0.030	3.50	X		T	
9.00	+/-0.030	9.00	X		T	
17.00	+/-0.030	17.00	X		T	
18.50	+/-0.030	18.50	X		T	
33.40	+/-0.030	33.40	X		T	
34.25	+/-0.030	34.25	X		T	
34.60	+/-0.030	34.60	X		T	
34.72	+/-0.030	34.72	X		T	
22.85	+/-0.030	22.85	X		T	
19.15	+/-0.030	19.15	X		T	
35.39	+/-0.030	35.39	X		T	
0125	+/-0.010	1130	X		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 10-8-10	Date: 10/08/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.06.22	New Issue	KJ	

0.125
REF



D3935-1 PYLON WALL PROTECTOR, LH
(TEXTURED SIDE SHOWN)

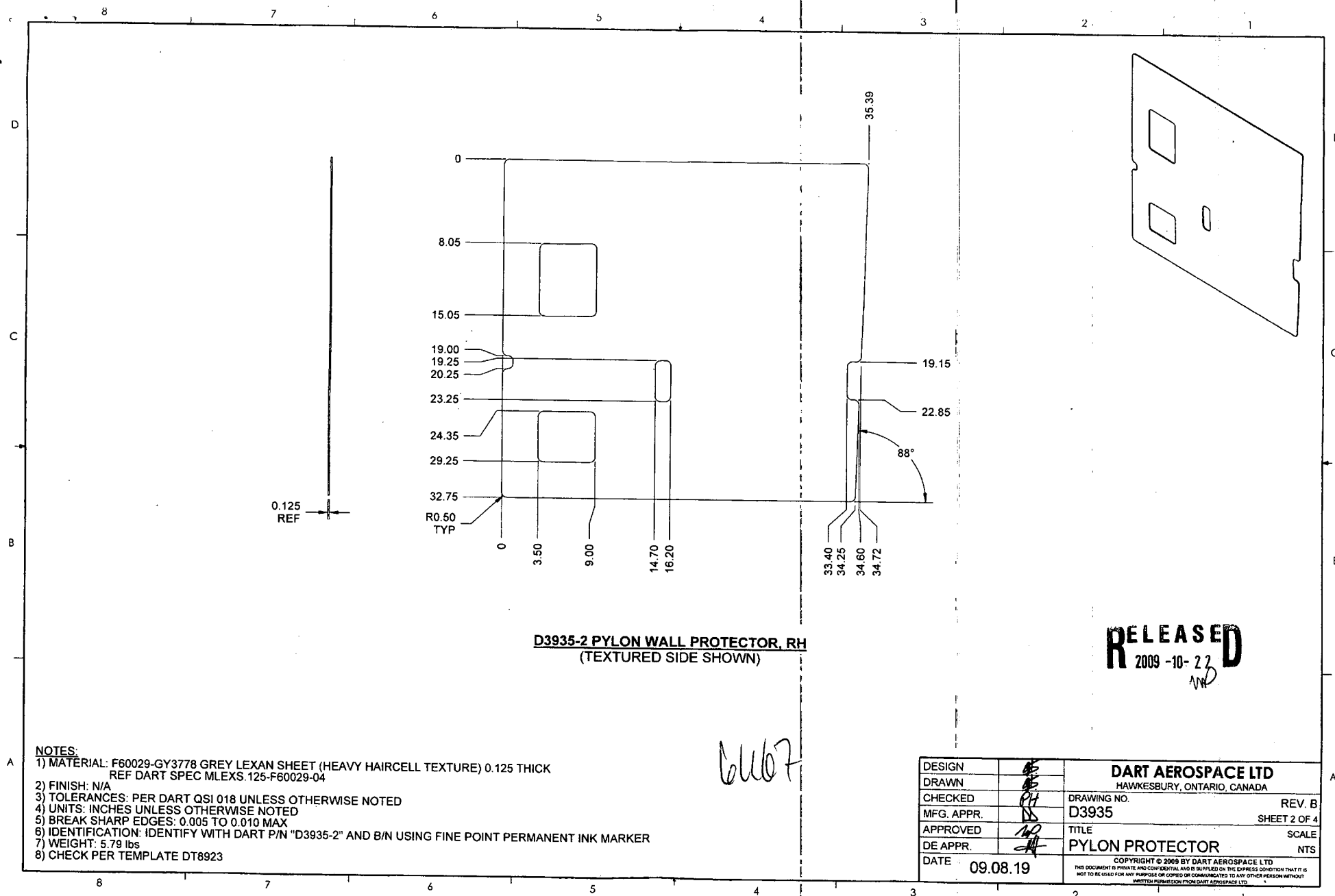
RELEASED
2009-10-22

NOTES:

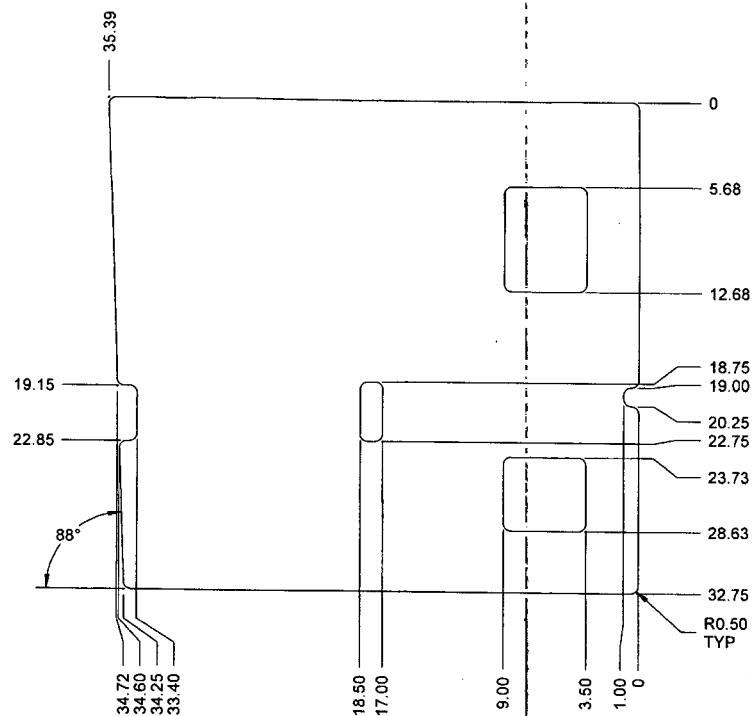
- 1) MATERIAL: F60029-GY3778 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK
REF DART SPEC MLEXS.125-F60029-04
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3935-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 5.79 lbs
- 8) CHECK PER TEMPLATE DT8922

B	ADD -3, -4 (SHEET 3, 4)	HS	09.08.19
A	NEW ISSUE	HS	09.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.08.19		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3935	REV. B
TITLE PYLON PROTECTOR	SCALE NTS
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0.125
REF



D3935-3 PYLON WALL PROTECTOR, LH
(TEXTURED SIDE SHOWN)

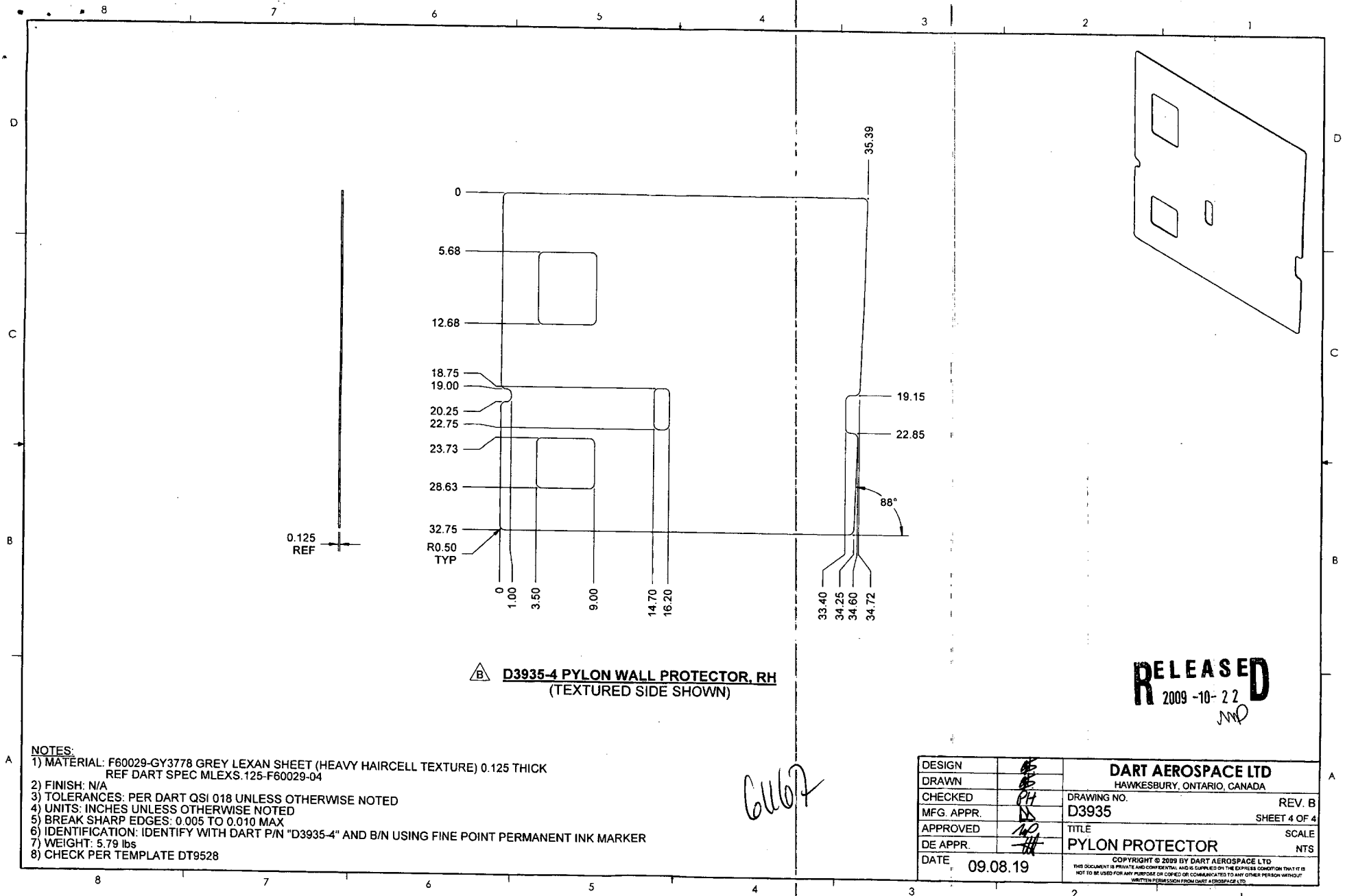
NOTES:

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REF DART SPEC MLEXS.125-F60029-04
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- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3935-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 5.79 lbs
- 8) CHECK PER TEMPLATE DT9527

6667

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CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	DS	D3935	SHEET 3 OF 4
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DE APPR.	SH	PYLON PROTECTOR	NTS
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NOTES:

- 1) MATERIAL: F60029-GY3778 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK
REF DART SPEC MLEXS.125-F60029-04
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3935-4" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 5.79 lbs
- 8) CHECK PER TEMPLATE DT9528

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MFG. APPR.	AS	D3935	SHEET 4 OF 4
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